

Work Order ID 161064

Monday, May 08, 2017 9:09:03 AM

161064

Page 1

Item ID: PB67-43001-181

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cover Plate

Start Date: 5/8/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/31/2017 Req'd Qty: 2.00

2

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: DAS 21 Date: MAY 08 2017

Tooling:

Date:

Run Start

NR1QC: 9-89 Date: _____ SPC (Y/N): _____

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-181	D								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.11

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: PProg Rev: D

****Grain direction along 7.19" ****

2-Deburr if necessary

(2) SC/a 17/05/09

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.02

Quality Control

(2) SC/a 17/05/09

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Page 2

Setup Start *NS1*

Stop *NS2*

?

Start Date: 5/8/2017 **Start Qty:** 2.00

Required Date: 5/31/2017 Req'd Qty: 2.00

Customer:

Reference: SCHEDULED/U

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

QC

Memo

0.04

Quality Control

MAY 10 2017

0.15

130

Brake NC

Memo

0.10

Brake NC

Bend as per Dwg B67-43001

DAS
30
9-89

MAY 10 2017

0.00

140

QC

Memo

0.04

Quality Control

MAY 10 2017

Work Order ID 161064

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Page 3

Item ID: PB67-43001-181 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cover Plate
Start Date: 5/8/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/31/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150	HandFinish	0.15				(2)	0		20170511
Hand Finishing	Memo								BEB
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160	Powdercoat	0.10				2	0	17.05.19.	20170519
Powder Coating	Memo								
	START TIME: 9:35								
	OVEN TEMPERATURE: 220								
	FINISH TIME: 10:05								
170	QC3- Inspect Part Finish	0.00							
170	QC	0.02				2			DAS
Quality Control	Memo								38

MAY 19 2017

Work Order ID 161064

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161064

Page 4

Item ID: PB67-43001-181**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Cover Plate**Start Date:** 5/8/2017 **Start Qty:** 2.00 ***2*****Cust Item ID:****Required Date:** 5/31/2017 **Req'd Qty:** 2.00 ***2*****Customer:****Reference:** SCHEDULED/U**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.02

Packaging

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.04

Quality Control

DAS
38
1-89

2

JUN 13 2017

200

PURCHASING

0.00

200

Purchasing

Memo

0.00

Purchasing

ISSUE P/O: 36403
SEND TO TALMAR FOR FOAM AND FABRIC
C OF C IS REQUIRED

2

MAY 23 2017

DAS
13
9-89

Work Order ID 161064

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161064

Page 5

Item ID: PB67-43001-181 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cover Plate
Start Date: 5/8/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/31/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Receive & Inspect for Damage & Mat'l Certs	0.00							
210									
Packaging	Memo	0.04							
Packaging									
220	QC6- All purchased or subcontracted products	0.00							
220									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: 	0.00							
230									
Packaging	Memo	0.02							
Packaging									

DAS 38 9-89 **2** **JUN 13 2017**

DAS 18 9-89 **2** **JUN 13 2017**

Work Order ID 161064

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161064

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Item ID: PB67-43001-181

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cover Plate

Start Date: 5/8/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/31/2017 Req'd Qty: 2.00

2

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.20

Quality Control

DAS
21
9-89

JUN 13 2017

Picklist Print

Monday, May 08, 2017 9:09:03 AM

Page 1
T

Work Order ID: 161064

161064

Parent Item: PB67-43001-181

PB67-43001-181

Parent Item Name: Cover Plate

Start Date: 5/8/2017

Required Date: 5/31/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-20 new issue DD verified by:ec
10.10.04 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	124.9400	1.0572	2.225684			

M2024T3S 032

2024-T3 .032 sheet

05/17/09

Location

Loc Qty

Loc Code

MAT022

124.94

M134581

3

M135010

1.6

M135032

6

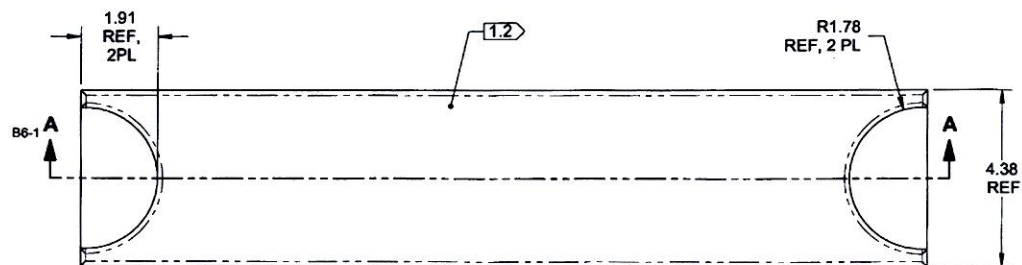
M136687

18.34

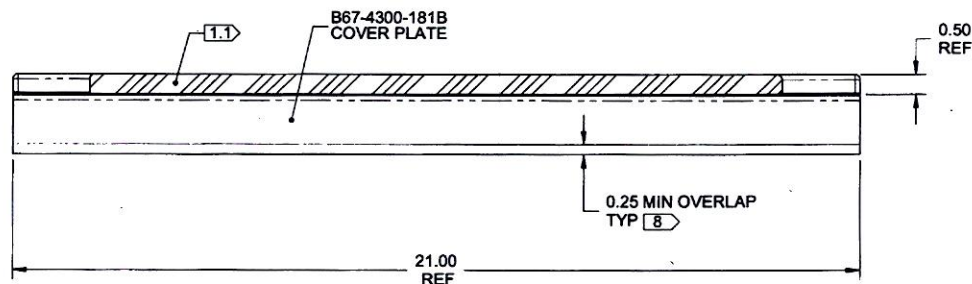
M137435

96

2.4



B67-43001-181 COVER PLATE ASSEMBLY



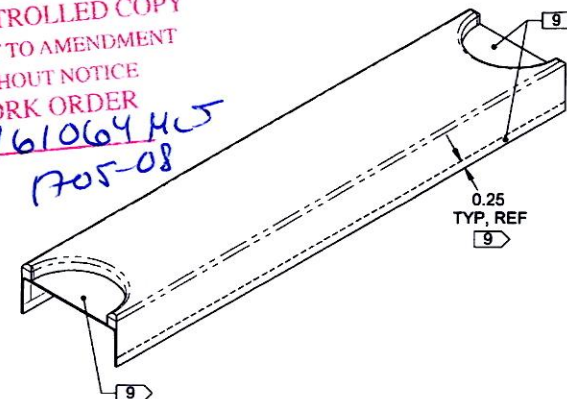
SECTION A-A D8-1

NOTES:

- 1) MATERIAL:
 - 1.1) FOAM: SBR/EPDM/CR BLEND, BLACK, ASTM D1056 2A2, 1/2" THICK, BRITTLENESS TEMP OF -40F, IAW ASTM D 746, FMVSS 302
 - 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK REF. TULMAR P/N 1495
- 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009 OR LA4009NOVOC
- 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
- 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs REF
- 8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE
- 9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDE

ITEM	QTY -181	P/N	DESCRIPTION
	X	B67-43001-181	COVER PLATE ASSEMBLY
1	1	B67-43001-181B	COVER PLATE
2	A/R	FOAM	SEE NOTE 1.1
3	A/R	FABRIC	SEE NOTE 1.2
4	A/R	ADHESIVE	SEE NOTE 1.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 161064 HJS
1705-08

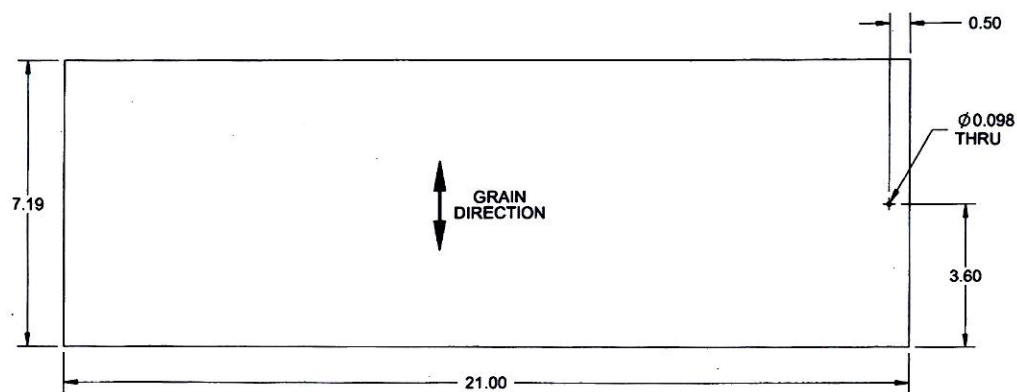


RELEASED
2014-12-08

D	FOAM AND ADHESIVE SPEC CHANGE TO MATCH SUPPLIER MATERIAL. REASON: SEE PAR #14-333	DB	14.07.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC. 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 10 AND 29 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	14.07.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-181 TITLE COVER PLATE SCALE NTS REV. D SHEET 1 OF 2 COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

TABLE 1

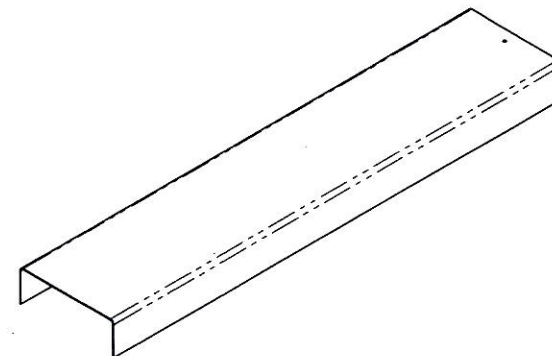
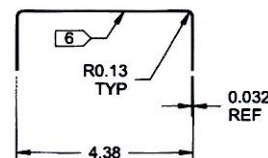
TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)
±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5: DIMS EQUAL TO OR > 40



B67-43001-181F FLAT PATTERN



B67-43001-181B BENDING DETAIL
(MAKE FROM B67-43001-181F)



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDEXX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-181B" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.48 lbs

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-181	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	COVER PLATE	NTS
DATE	14.07.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COMBOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-12-08
MP



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36403**

Purchase Order Date 5/23/2017

PO Print Date 5/23/2017

Page Number 1 of 2

Order From :

VC-TUL001

TULMAR SAFETY SYSTEMS
1123 CAMERON ST
HAWKESBURY, ON K6A 2B8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 25 2017

Contact Name

Vendor Phone 613 632 1282

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	D3949-041P	Remove before Flight Flag Assembly	6/14/2017		10.00	\$25.82	\$258.20
			Yes		Each		
			6/14/2017				
AS PER DGW D3949 REV. B B161483							
						Line Total:	\$258.20
3	161064	PB67-43001-181 COVER PLATE	6/14/2017		2.00	\$130.00	\$260.00
			Yes				
			6/14/2017				
FOAM AND FABRIC AS PER DWG PD67-43001-181 REV. D TULMAR P/N: 8421-103							

SP17-69

Line Total:

\$260.00

Note:

5/23/2017

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8

Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No Page

60432 1

Ship Date
6/8/2017

Bill To:

Dart Aerospace

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To:

Dart Aerospace

1270 Aberdeen Street
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7
Canada

Order number	Sales order date	Account number	Loc	Account manager
34911	5/25/2017	CDART100	H	Francine Bigras
PO number	Ship via	Shipping Terms		
P036403	Pick-Up	FOB HAWKESBURY		
Item No. Description	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order

Line 5 - Procurement QA Clauses:
A004 A005 A007 A016 A026 A040
A041 A043(TSS=5 yrs only)

8421-103
Cover Plate

2.00 EA

2.00

Drawing No: B67-43001-181
DWG Rev: D
Line 3
SF 42142
CUSTOMER PICKUP

Lot no.: BATCH0000000012

2.00

SP17-6-9.

Certificate of Conformance

☒ See Certification Enclosed

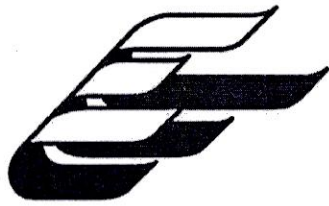
I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Loraine LaLiberte

Date:

JUN 08 2017



J. ENNIS FABRICS

June 10, 2015

Fax To: Tulmar Safety Systems
Fax: 613-632-2030
Attention: Sandra Nadeau

Certificate of Conformance

Re: PO 28594-00 for Oxford 7 black

The goods shipped on P/O 28594-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford 7 black is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish; Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Piece # 111926200 Manufacture Date: 03/25/15, Lot Number: 444815

Sincerely;
J. Ennis Fabrics Ltd.

S, Nolan

Susan Nolan
Customer Service Specialist

JUN 19 2015



1495 # 33
B

QC's used to mfg. B67-43001-181
Rev. D.

Sandra LaLiberte (QC).
June 8/17

TULMAR**Certificate of Conformance**

Tulmar P/N 1637-001	Description 1/2" X 42" X 72"	Dwg #	Revision	Qty 4
Tulmar PO # 30168-00	Line Item # 01	Supplier Name / Address AM RUBBER & FOAM GASKETS INC 2074 STEELES AVE EAST, UNITS 1 & 2 BRAMPTON, ON L6T 4Z9		Supplier Packing Slip # 16428

Supplier Declarations:

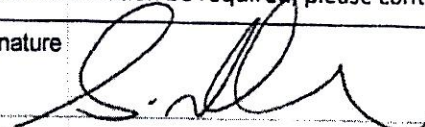
Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : CANADA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

FOAM, SBR/EPDM/CR BLEND, BLACK ASTM D1056 2A2, 1/2"TH. SHEET SIZE 42" X 72" +/-0.5" BRITTLNESS TEMP OF -40 DEGREES F IAW ASTM D746, FMVSS 302. QUALITY CLAUSE: GrBT3

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name SANDRA PULSINELLI	Date (DD-MMM-YYYY) 07-06-2016
Title PRODUCTION	Email sandra@amrubber.ca	Phone # 905-455-1449

1637-001**JUN 16 2016**

Form Revision 13 Aug 2012

3#9



48 Burgess Place
Wayne, NJ 07470

Certificate Of Analysis

2/17/2017

Sales Order Number: 9425
Customer Order Number: 30970

Manufactured for
TULMAR SAFETY SYSTEMS

4172-C6.9A LA4009NOVOC, P/N 7122-001 14172-C6.9A - LA4009NOVOC, UNLINED GALLON CAN

Lot# PNJ-0117-0331 Qty: 53 CANS + PART CAN @ 3# Manufacture Date: 2/1/17 Expiration Date: 2/1/18

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	15.0000	13.00	15.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	1,015.0000	800.00	1,500.00	Centipoise
Visual check for dry film color	pass	(CLEAR TO HAZY YELLOW) PASS/FAIL		

4556-S1.9 CAT7020, P/N 7153-002 14556-S1.9 - CAT7020 QUART CANS SQUARE UNLINED

Lot# PNJ-0117-0329 Qty: 11 EA Manufacture Date: 2/14/17 Expiration Date: 8/14/17

Test(s)	Results	Min	Max
	NOT APPLICABLE	NA	NA

4914-C7 DB7020M1, P/N 7153-001 14914-C7 - DB7020M1, GALLON LINED CAN

Lot# PNJ-0117-0332 Qty: 52 CANS + PART CAN @ 5# Manufacture Date: 2/3/17 Expiration Date: 8/3/17

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	23.7000	21.00	24.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	835.0000	450.00	1,250.00	Centipoise

"The material supplied conforms to all applicable engineering drawing, specifications and PO requirements."

Dan Constantino

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Country of Origin: USA

7122-001
B#10

FEB 28 2017

